

Work Order ID 62853

Tuesday, October 12, 2010 11:42:53 AM



Page 1

Item ID:	D2221	Accept		Setup	Start	
Revision ID:						
Item Name:	350 Basket Base				Stop	
Start Date:	10/12/2010	Start Qty:	1.00			
Required Date:	10/22/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	10/10/10	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2221	Rev H								

100		0.00							
	Large Fab								
Large Fab		0.00							

Memo

- 1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
- 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
- 3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch:

1.5 - drill holes for gas spring ~~in~~ in D3425-041 as per DSI 9473

110		0.00							
	QC								
QC		0.00							
Quality Control									

Memo

QC9- Inspect visual per QSI004- Fusion Welds

PD 10.10.15

Cpl 10.10.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



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Required Date:	10/22/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC6- Inspect dimensions to drawing Memo holes for gas spring were drilled @ each end.	0.00 0.00				<u>1</u>			<u>10/10/20</u>
125  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							<u>BR 10-10-20</u> <u>①</u>

Dart Aerospace Ltd

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Setup Start

Stop

00000000000000000000000000000000

Cust Item ID:

1000

Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

[illegible]

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00 BR 10-10-20



M115291

0.00

Powdercoat

Memo

Powder Coating

1- Plug holes prior to

1ST COAT:

START TIME: 12:30

OVEN TEMPERATURE: 400°

FINISH TIME: 1:00

*****2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE: _____

FINISH TIME: _____

QC3- Inspect Part Finish

0.00

Abstract

Memo

0.00

OC

Quality Control

ES10/10/21 ©

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Item ID: D2221 Accept  Setup Start 
Revision ID: Stop 
Item Name: 350 Basket Base
Start Date: 10/12/2010 Start Qty: 1.00  Cust Item ID:
Required Date: 10/22/2010 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Packaging Packaging	Identify as per dwg & Stock Location: <i>G-A</i> Memo <i>w/o</i> <i>62847</i>	0.00 0.00							<i>E/S 10/10/21 @</i>
160  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>10/10/27 DJ</i> <i>PL 10-10-29</i> <i>C</i>

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Tuesday, October 12, 2010 11:42:57 AM

[illegible][illegible]**Required Date:** 10/22/2010

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 		Manufactured	No			100	Each	14.0000	1	1			
Rib										PD 10.10.14			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				14					
					61091			2					
					61424			12					
D2221-5 		Manufactured	No			100	Each	12.0000	2	2			
Rib										PD 10.10.14			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				12					
					60957			4					
					61753			8					
D2221-7 		Manufactured	No			100	Each	6.0000	1	1			
Rib										PD 10.10.14			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				6					
					61180			2					
					61754			4					

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Picklist Print

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Work Order ID: 62853



Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No

100

Each

8.0000

2

2



Basket Hinge



PD 10.10.14

Location

Loc Qty

Loc Code

WA

8

61182

2

61755

6

②

D2235-1 Manufactured No

100

Each

16.0000

2

2



Basket Rib



PD 10.10.14

Location

Loc Qty

Loc Code

WA

16

61471

6

62254

10

②

D2581 Manufactured No

100

Each

51.0000

2

2



Mounting Bracket



PD 10.10.14

Location

Loc Qty

Loc Code

WA

51

60470

31

61953

20

②

D3442-1 Manufactured No

100

Each

16.0000

2

2



Shim



PD 10.10.14

Location

Loc Qty

Loc Code

WA

16

60177

4

61181

12

②

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Shop Packet Print

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

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Work Order ID: 62853

Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 10/12/2010



Required Date: 10/22/2010

Start Qty: 1.00



Required Qty: 1.00

D3825-041 Manufactured No 100 Each 8.0000 2 2
  PD 10.10.14
 Rib Assembly (Basket End)



Location	Loc Qty	Loc Code
WA	8	
61179	2	
61757	6	

D3826-041 Manufactured No 100 Each 8.0000 2 2
  PD 10.10.14
 Rib / Gusset Assembly

Location	Loc Qty	Loc Code
WA	8	
61178	2	
61676	6	

D3827-041 Manufactured No 100 Each 9.0000 1 1
  PD 10.10.14
 Rib Assembly (Inboard)

Location	Loc Qty	Loc Code
WA	9	
61177	3	
61758	6	

D3832-1 Manufactured No 100 Each 3.0000 1 1
  PD 10.10.15
 Mesh (Base)

Location	Loc Qty	Loc Code
WA	3	
61451	3	

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Work Order ID: 62853



Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

14.0000

2

2



8D 10.10.15

Mesh (Base End Face)

Location

Loc Qty

Loc Code

WA

14

61285

6

62383

8

①

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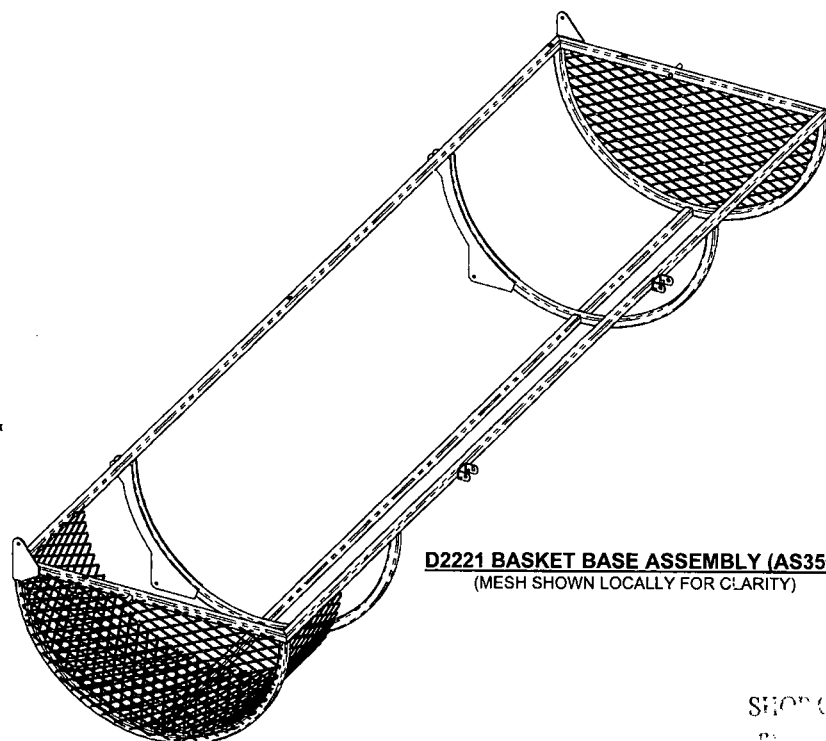
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
UNCONTROLLED COPY
NO. 62853
2/10/12

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: 42.00 lbs APPROX
 - 9) MASK ALL HOLES PRIOR TO POWDER COATING

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RECEIVED
08/11/12

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN D6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW REF (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

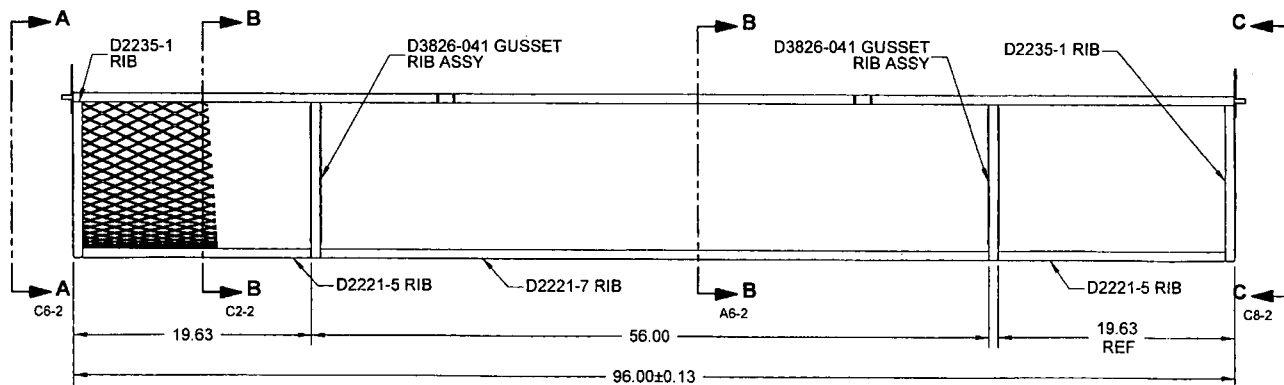
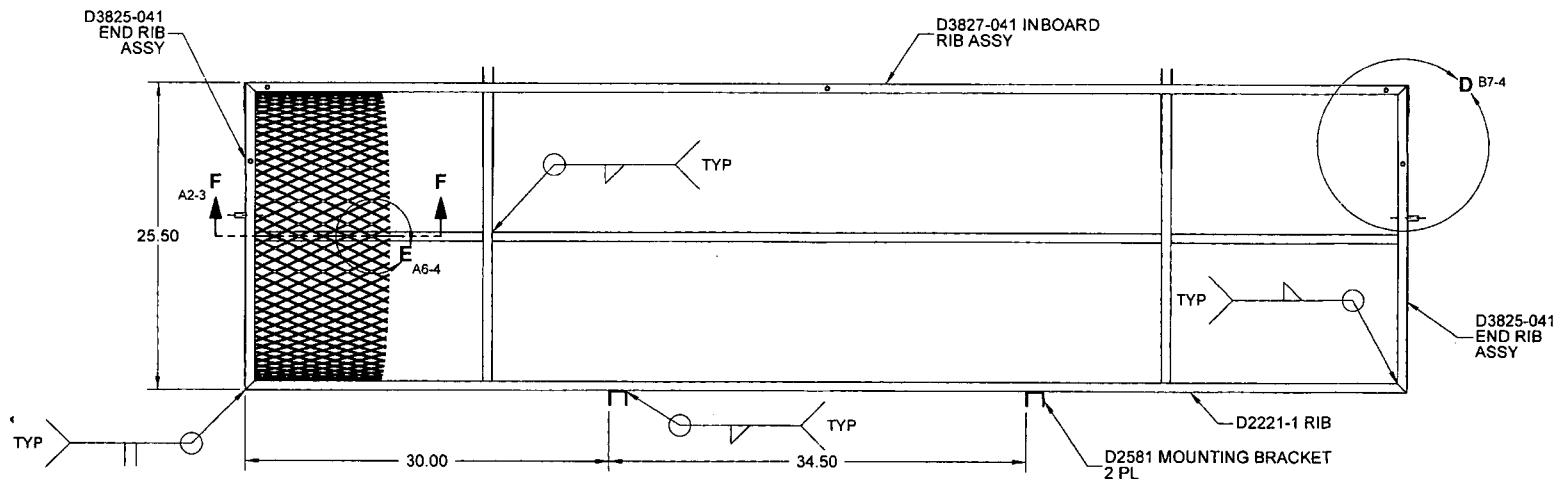
Dart Aerospace Ltd

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D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18 NAD

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	
DATE	08.09.18	NTS	
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also 62853

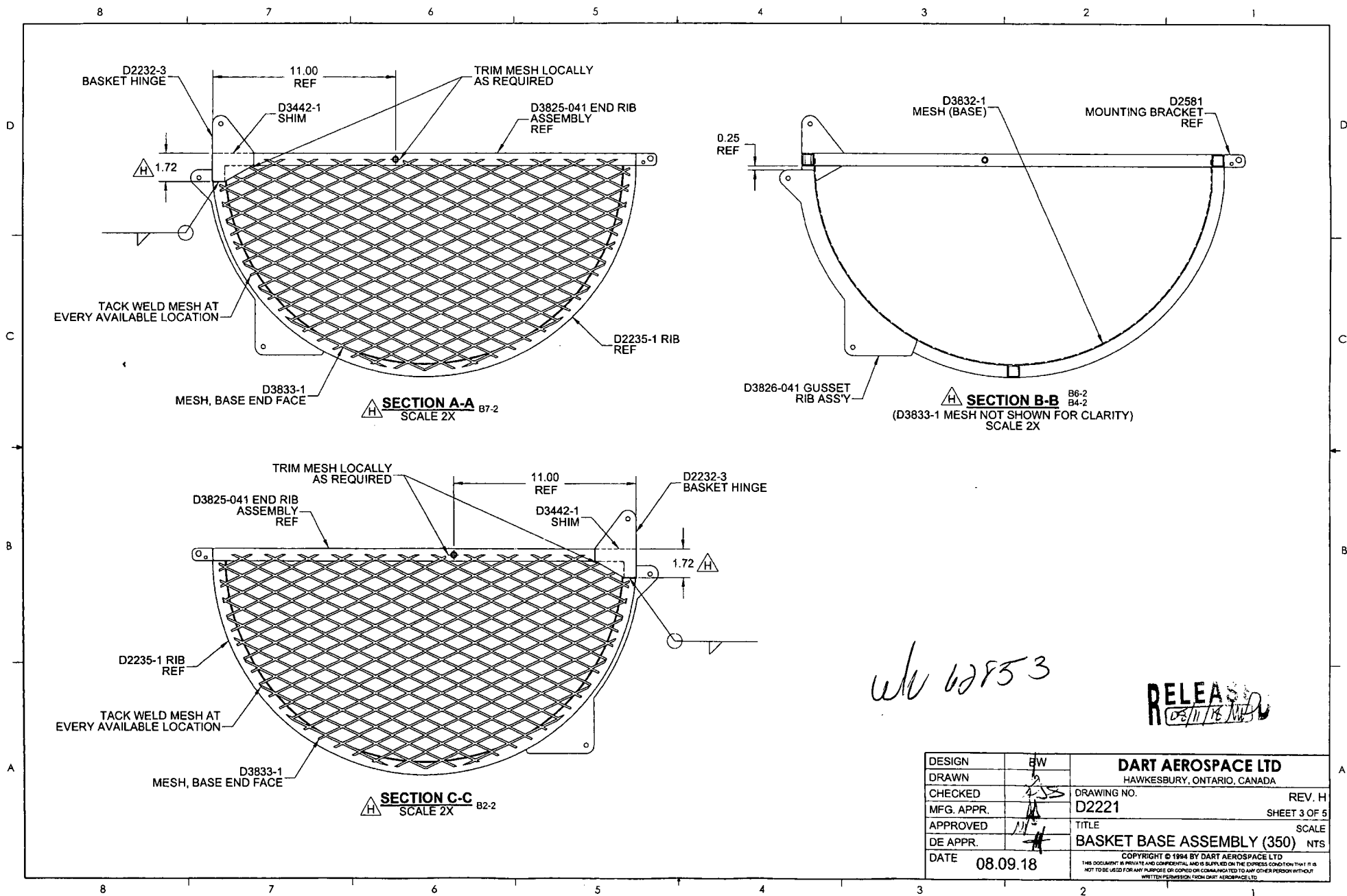
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DESIGN	BW	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4-3-3	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 3 OF 5
APPROVED	11/1	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

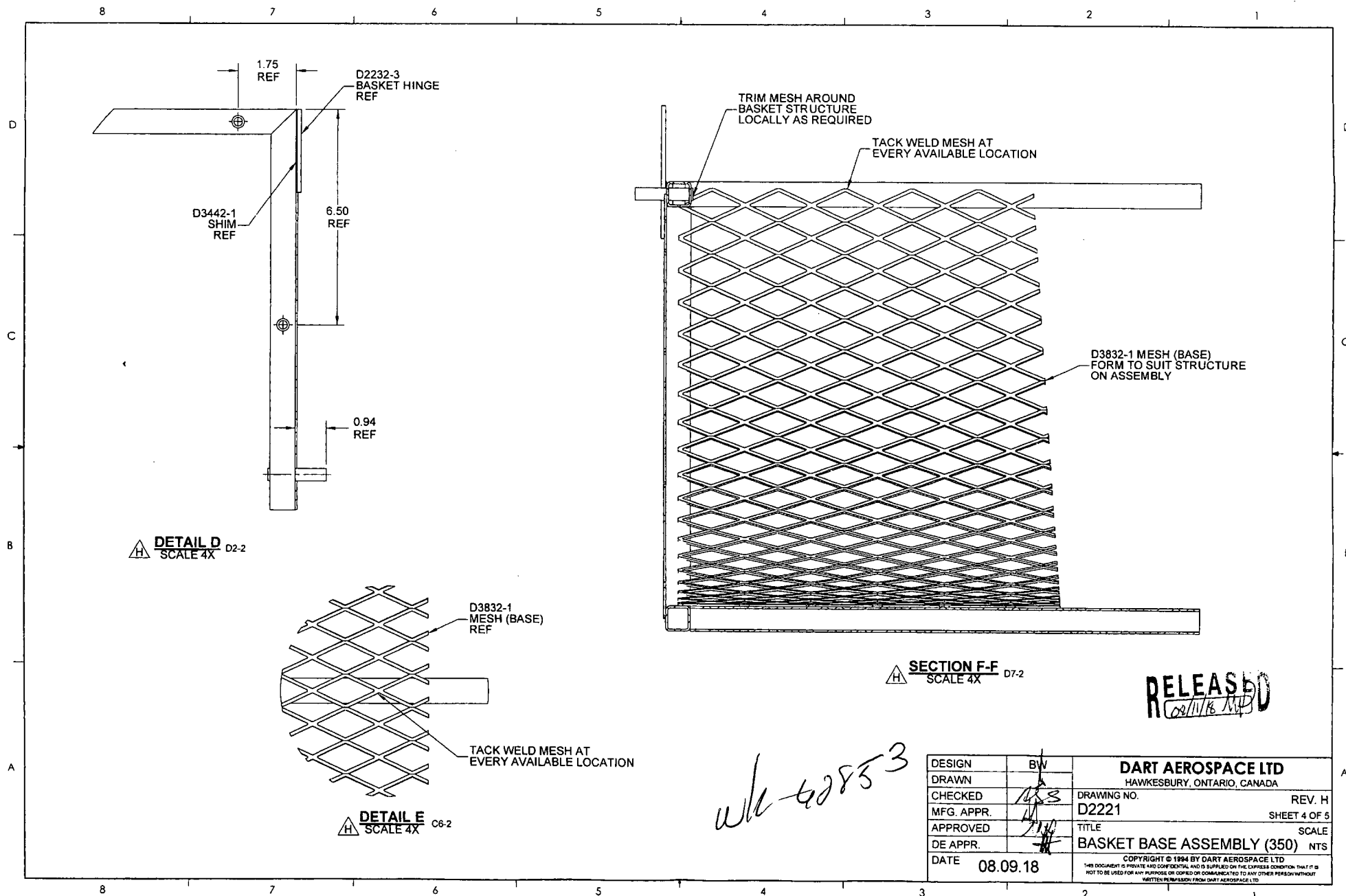
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



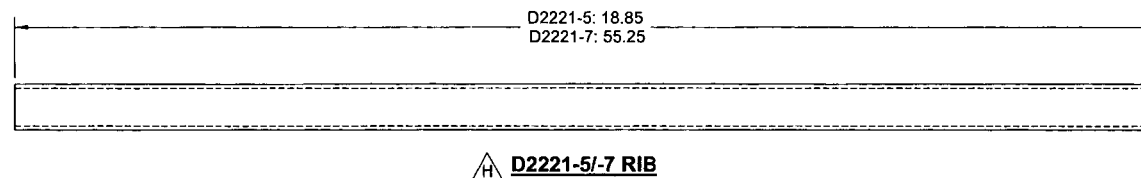
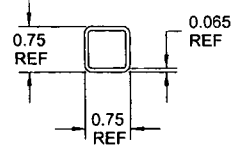
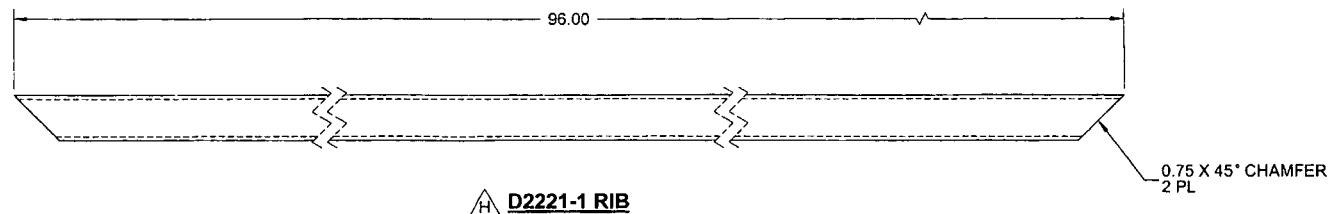
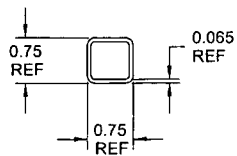
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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RELEASED
08/10/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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